

Date: Friday, 25/04/2008 8:18:43 AM
 User: Jean-Luc Menard

Process Sheet

SPRINTED

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE FITTING
Job Number	: 38786		
Estimate Number	: 12299		
P.O. Number	:	Part Number	: D3488041
This Issue	: 25/04/2008 S.O. No. :	Drawing Number	: D3488 / DSK101
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B / D
Previous Run	: 38465	Material	:
Written By	: <i>Just/02.04.25</i>	Due Date	: 02/05/2008
Checked & Approved By	:	Qty:	<i>16</i> Um: Each
Comment	: Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM Est Rev:C Now On Doosan Lathe JLM Verified BY:DD		<i>16</i> <i>17</i>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	Round Billet, Aluminum
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)
 Alluminum Round Billet D6103-003
 Batch: *36236*

Re 08/04/25

(17)

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

ml/Re 08/04/25

(17)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml/Re 08/04/25

(17)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA625 & Dwg D3488

2-Deburr

ml 08/05/11

(17)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/05/11

(17)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38786

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 08/05/13 (17)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L / RD 08/05/13

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:35

OVEN TEMPERATURE:

3/9

FINISH TIME:

4:05

FL 08/05/13 (17)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/05/14 (17X)

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M100489

M-L

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

M-L 08/05/14 (17X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/14 (17)

DART AEROSPACE LTD		Work Order: 38786
Description: Blade Fitting, LH		Part Number: D3488-1
Inspection Dwg: D3488	Rev: B	Page 1 of 1

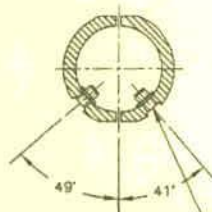
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.128	✓			
2.620	+/-0.010	2.618	✓			
0.793	+/-0.010	.800	✓			
1.351	+/-0.010	1.343	✓			
1.317	+/-0.010	1.312	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.807	✓			
Ø0.508	+0.006/-0.001	Ø.510	✓			
R0.062	+/-0.010	R.062	✓			
1.500	+/-0.010	1.498	✓			
8.000	+0.030/-0.000	8.010	✓			
11.18	+/-0.030	11.188	✓			
Ø0.484	+0.005/-0.001	Ø.486	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.065	✓			
0.590	+/-0.010	.588	✓			
0.125	+/-0.010	.131	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.499	✓			
Ø0.297	+0.005/-0.000	Ø.302	✓			
Ø0.430	+/-0.010	Ø.434	✓			
0.100	+/-0.010	.107	✓			

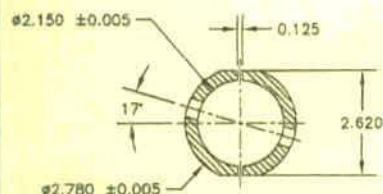
Measured by: [Signature]	Audited by: DTP	Prototype Approval:	N/A
Date: 08/05/11	Date: 08/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM [Signature]	[Signature]



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



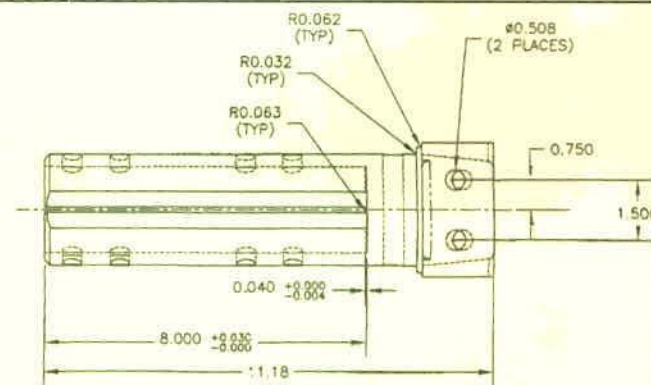
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

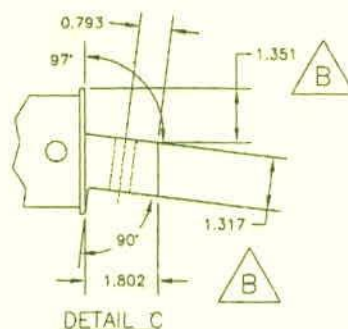
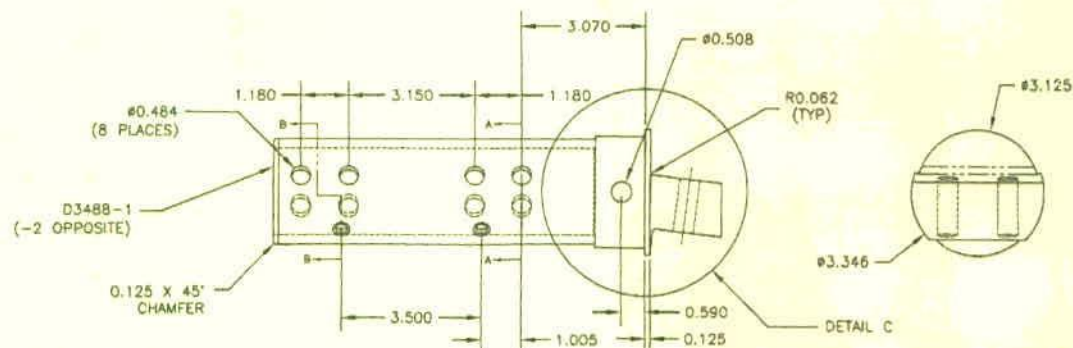
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



W/O 38286

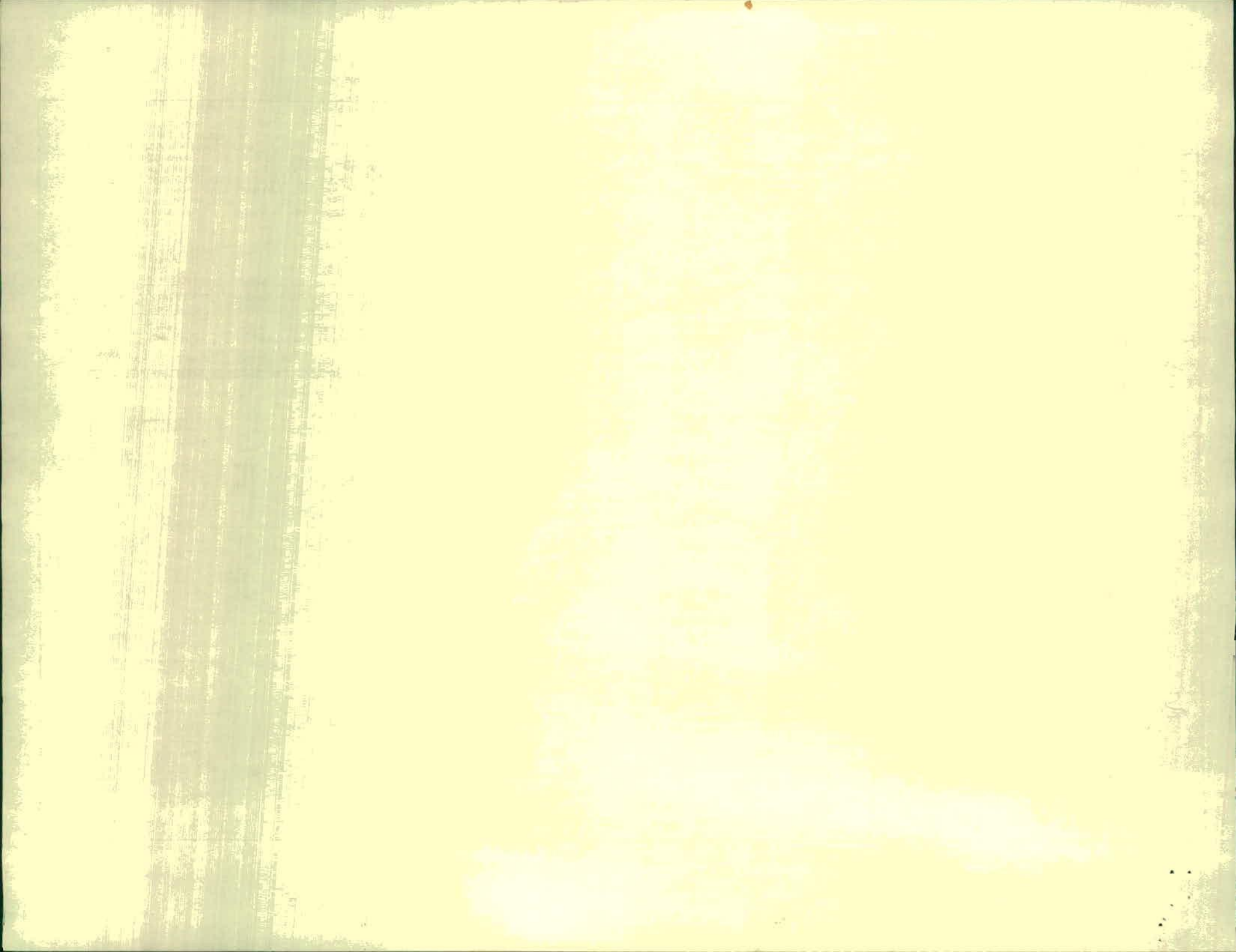


D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
REV. 05
EWN #787

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE USA, INC.
DRAWN BY	PH	
CHECKED	A	D3488
APPROVED	A	
DATE	06.03.15	BLADE FITTING
REV. B		SHEET 1 OF 1
SCALE		1:3

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DART**DART AEROSPACE USA, INC.**
PORT HADLOCK, WA

REV. D

SHEET 1 OF 1

DESIGN

PH

DRAWN BY

PH

CHECKED

PH

APPROVED

PH

DRAWING NO.

DSK 101

DATE

06.05.09

TITLE

D3488-1/-2 TURNING DETAIL

SCALE

1:3

A

05.12.21

NEW ISSUE

B

06.03.02

ADD TOLERANCES AND RADIUS

C

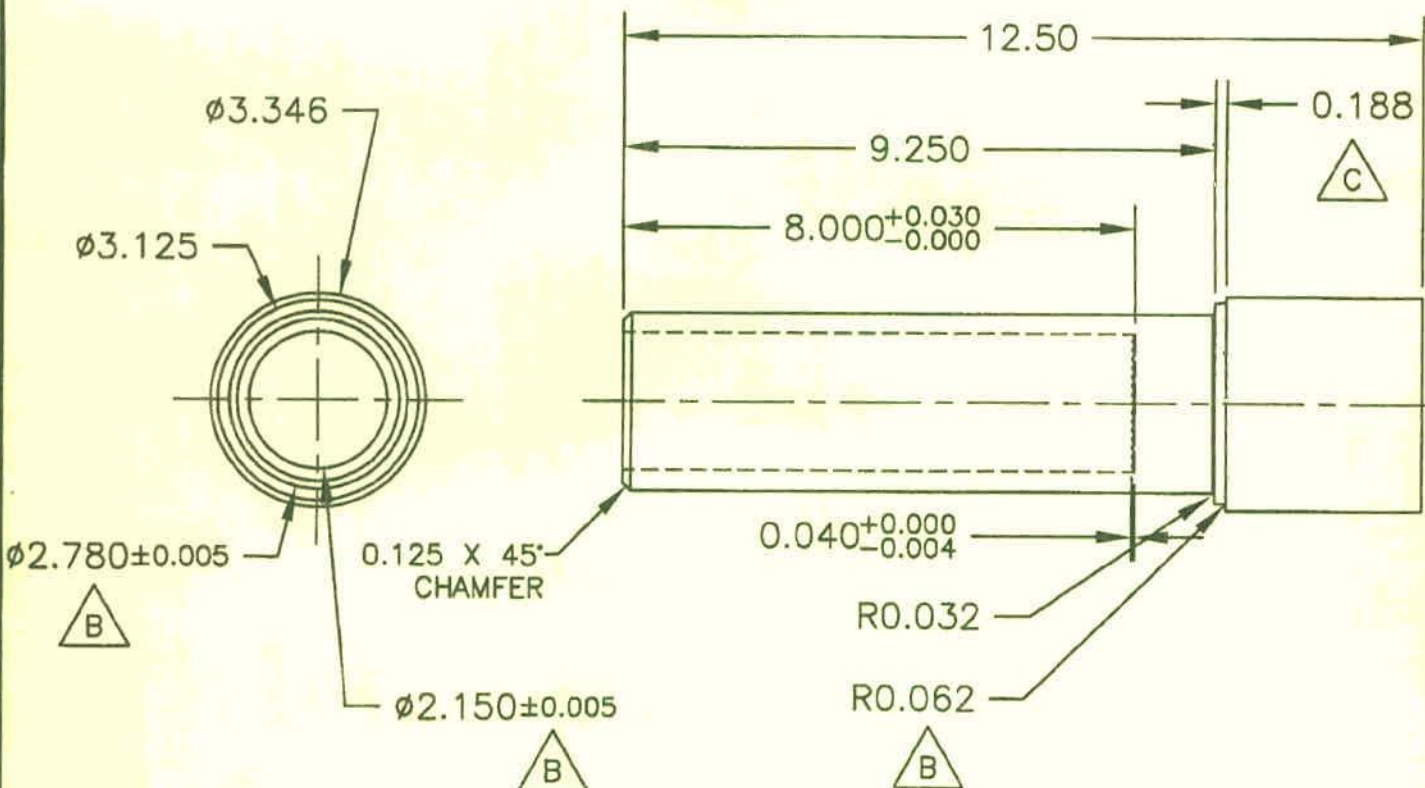
06.04.17

0.188 WAS 0.125

D

06.05.09

REMOVE DIAMETER FOR CHAMFER

*06-05-09 PH**w/o 38786***DSK 101**

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3488-041 PAR #: N/A Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: D Date: 08/05/14
 QA: N/C Closed: D Date: 08/05/15

NCR: <u>38786</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/28	2.0	1 piece, the interior of the hole have a big groove R.C. chip build up on back on 1st drilling cycle	<u>[Signature]</u> 08/04/28	Scrap and Destroy and to replace. B# <u>36236</u>	<u>[Signature]</u> 08/04/28	<u>[Signature]</u> 08/04/28	<u>[Signature]</u> 08/04/28	<u>[Signature]</u> 08/04/28
08.04.28	2	Minor chatter mark @ 7.53" deep SEE SPLIT W/O SPLIT-2	<u>[Signature]</u> per QAR 042 08.04.28	ACCEPTABLE DEVIATION SPLIT SPLIT ONTO SEPERATE SHEET	<u>[Signature]</u> 08/04/28 RH	<u>[Signature]</u> 08/04/28	<u>[Signature]</u> 08/04/28	<u>[Signature]</u> 08.04.28

NOTE: Date & initial all entries

